Qty:

20 Um:

Each

: CONSOLE BRACKET HI-SLOPE

: D2606

: N/A

: A1

: NA

: 10/04/2007

: D2606 REV A1

Date:

Friday, 23/03/2007 6:06:58 AM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31334

Estimate Number

: 11004

P.O. Number This Issue

· HIA

: 23/03/2007

S.O. No. : NIA

Prsht Rev.

Previous Run

First Issue

: 31334

Type

: SMALL /MED FAB

Written By **Checked & Approved By**

Comment

D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

2024-T3 .040 sheet

1.0

2.0

M2024T3S040

Comment: Qty.: 0.1582 sf(s)/Unit Total: 3.1647 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

Stack of 10

(M2024T3S.040) Batch M104025

07 04 19

FLOW WATER JET



Comment: FLOW WATER JET

WATER JET

1-Cut as per Dwg D2606

Dwg Rev: A1 Prog Rev: A

M of 04 19

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

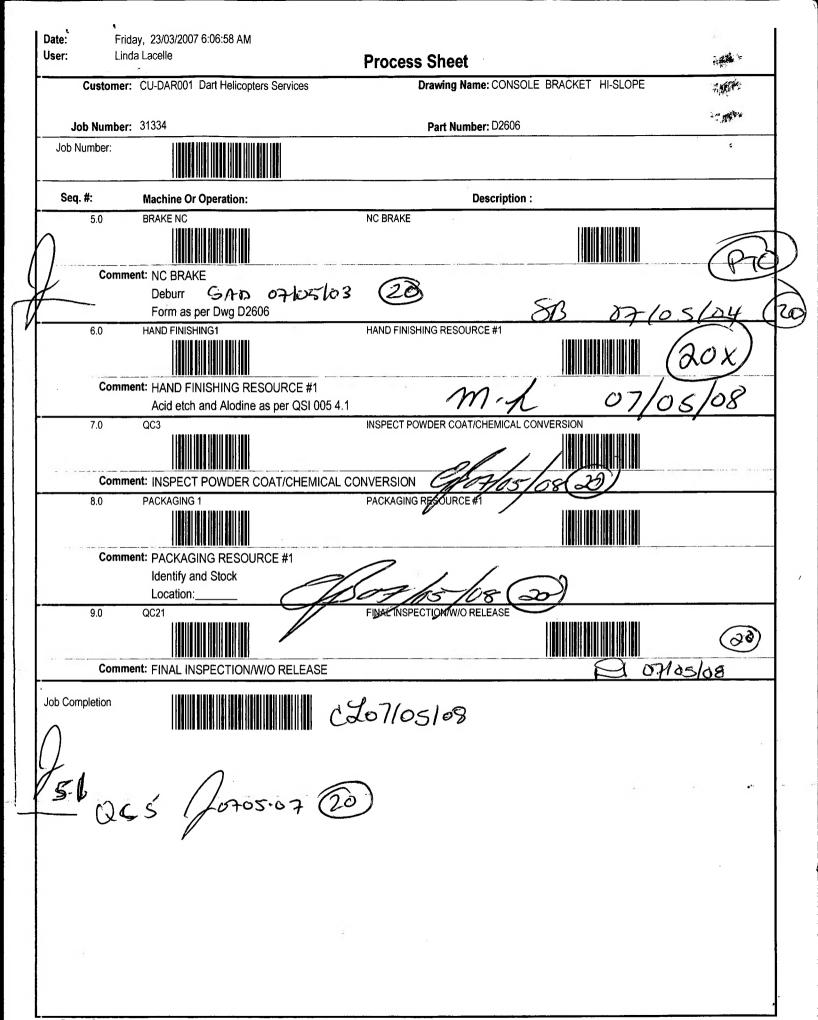
Comment: SECOND CHECK

SECOND CHECK



Page 1

Form: rprocess



Date: User: Tuesday, 3/20/2007 12:03:31 PM

Kim Johnston

Process Sheet

Customer ...

Job Number

: CU-DAR001 Dart Helicopters Services

Type

Drawing Name

: CONSOLE BRACKET HI-SLOPE

: 31334

Estimate Number

: 11004

P.O. Number

: 3/20/2007 S.O. No. : Part Number

: D2606

This Issue Prsht Rev.

: NC

Drawing Number

D2606 REV A1

First Issue

: //

Project Number

: N/A

Previous Run

: 25142

Drawing Revision Material

: A1

Written By

Comment

Checked & Approved By

: Est. 98.11.26 Added Inspection

: MACHINED PARTS

Due Date

: 4/10/2007

Qty:

20 Um:

Each

Each

1: --

Additional Product

Job Number:

⊶Seq. #: 16.

J. 17

1. 1.



Description:

1.0 M2024T3S040



2024-T3 .040 sheet



Comment: Qty.:

0.1582 sf(s)/Unit

Total:

3.1647 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

Batch

Stack of 10

(M2024T3S.040)

SHEAR







HÀAS CNC VERTICAL MACHINING #1

3.0

ħ.

10 · water

.

2.0

SHEAR

Comment: HAAS CNC VERTICAL MACHINING #1

Cut Blank per template DT8247

Machine per folio D2606

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK





Comment: SECOND CHECK

· 154.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
0705.07	5.0	Add Qc 5 Perm. Change									
070501	Ç	Oc 5		C70527	20	1070507	105.07				
:											
							:				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							ł	•

NOTE: Date & initial all entries

Tuesday, 3/20/2007 12:03:31 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: CONSOLE BRACKET HI-SLOPE Customer: CU-DAR001 Dart Helicopters Services Job Number: 31334 Part Number: D2606 Job Number: Seq. #: -Description: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE Deburr Form as per Dwg D2606 HAND FINISHING1 HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005\4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE - More blanding -Job Completion

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		DAP #: Foult Catagony	NCP: Voc	No DO	۸.	Data	

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						
	Description of NC	Corrective Action Section B			Verification	Annroyal Annre	
DATE STEP Description of NC Section A				Section C	Chief Eng	Approval QC Inspector	
	*						
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Portion Section B Section A Portion C Section A Portion C Section C Secti

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31334
Description: Console Bracket	Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1

	FIR	ST ARTICLE	INSPEC	TION CI	HECKLIST		
••		X First A	rticle	Pro	ototype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	mments
0.841	+/-0.005	0.840	J		Hight Guage		
1.589	+/-0.005	1.590	1		Hight Gurge	_	
0.621	+/-0.010	0.624	\checkmark		Hight Guage		
1.809	+/-0.010	1.810	1		vern		
2.430	+/-0.010	2.438	1		VerN		
0.621	+/-0.010	0.625	J		Hight Gunge		
8.309	+/-0.010	8.309	J		VENN		
8.930	+/-0.010	8.932			Vern		
8.710	+/-0.010	2.712	J		VWN		
R0.250	+/-0.010	120.250	J		RAVIUS GUA	se	
R0.156	+/-0.010	RO.156	J		RAdius GuA	1 9	
Ø0.098	+0.005/-0.000	0.898	J		VerN	0	
0.040	+/-0.005	0.040	1		VIVN		+
		- V I-V					
9							
*							
Measured by:	and 100	Audited by	,	7	Prototype A	nnroval	N/A
Date:	M(,W) 07 04 19	Date		4.24	Prototype A	Date:	N/A N/A
Rev Date A 05.02.17	Change New Issue			`		evised by	Approxed

H:\FORMS\Ouality	Assurance\approved	OA\FAL revD

